

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003674**Date Inspected:** 14-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Bo**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Fabrication**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

Orthotropic Box Girder (OBG):

QC: Sun Bo

Heavy Tower Shop #3:

Around 1500 hours ZPMC QC representative Mr. Fu Yuhong informed the QA Inspector that ZPMC QC and ABF QA Inspection personnel have completed initial visual inspections of deck panels DP619-001 and the areas of the closed rib welds that need to be repaired have been marked by soapstone. The QA Inspector performed random visual inspections of each of the welds and two additional areas of weld overlap were identified by the QA Inspector as needing to be repaired. The QA Inspector documented the initial visual inspections on the yellow inspection status tag that is attached to the two deck panel.

SMR Mr. Ady Velasco informed the QA Inspector that Caltrans lacks documentation for the visual inspections of the following closed rib Production Monitoring Test (PMT) macroetches:
DP083-001 Specimen 83-3-3

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

DP110-001/DP488-001, 15 specimens
DP189-001/DP108-002 specimen 189-6-1
DP55-001/DP79-001, 15 specimens
DP432-001/DP054-001, 15 specimens
DP352-001/DP111-001, 15 specimens
DP408-001/DP113-001, 15 specimens

Mr. Velasco informed the QA Inspector that ABF/Fluor representative Mr. Kevin Dye is in the process of locating these macroetches and after they are re etched they will be available for QA visual inspections.

Today the QA Inspector was presented with DP083-001 Specimen 83-3-3, DP110-001/DP488-001, 15 specimens, DP189-001/DP108-002 specimen 189-6-1, DP55-001/DP79-001, 15 specimens, DP432-001/DP054-001, 15 specimens, and DP352-001/DP111-001, 15 specimens. Mr. Dye was not able to obtain DP408-001/DP113-001, 15 specimens.

The QA Inspector visually inspected and dimensionally measured the penetration each of these macroetch samples and Macroetch DP432-001/DP054-001#5-4 appears to have a scratch near the fusion zone and the other macroetches appear to comply with project specifications.

The QA Inspector recorded information for all PMT specimens on an Excel spreadsheet titled "SAS OBG PMT Macroetch Log" and a copy of this file is posted on the Caltrans "Team China" internal common drive which is accessible to all Quality Assurance personnel including Task Leaders and Structural Materials Representatives.



Summary of Conversations:

See above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco 13816942685, who represents the Office of Structural Materials for your project.

Inspected By: Dawson,Paul

Quality Assurance Inspector

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Reviewed By: Carreon,Albert

QA Reviewer